

Work Order ID 64596

December 9, 2010 8:57:23 AM



Page 1

Item ID:	D3188-2M	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	SPACEPOD BODY RH					
Start Date:	1/07/11	Start Qty:	1.00		Cust Item ID:	
Required Date:	1/07/11	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CX</u>	Date:	<u>10/12/09</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3188	Rev F

100		0.00							
	PURCHASING								<u>CX 10/12/09</u> <u>①</u>
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>13107</u>								
	Description: D3188-2MBODY								
	SHIP: QTY (8) D2213 Spacers								
	Ship to Delastek (1) D0600 XXX label								
	Batch: <u>58791</u> <u>asper David S</u>								
	Supplier: Delastek								
	Conformity Certificate and Process sheet required								
	Ship 2 Items from Previous steps								

110		0.00							
	Receive & Inspect for Damage & Mat'l Certs								<u>P4/3/2</u> <u>①</u>
Packaging	Memo	0.00							
Packaging	Ensure a copy of certification of conformity and process sheet from Delastek is attached.								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64596

December 9, 2010 8:57:23 AM



Page 2

Item ID: D3188-2M

Accept



Setup Start



Revision ID:

Stop



Item Name: SPACEPOD BODY RH

Start Date: 1/07/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/07/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

0.00 8/11/03/02

Memo

Check for void spot and pins.

70

130



Packaging

Packaging

Identify as per dwg & Stock Location: composer 0.00

Memo

0.00

25 11-03-02

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/03/03
UME
11-03-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 9, 2010 8:57:23 AM

Page 1

Work Order ID: 64596

Parent Item: D3188-2M

Parent Item Name: SPACEPOD BODY RH

Start Date: 1/07/11

Required Date: 1/07/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC
IPP rev B rev D dwg 07.03.07 ec
IPP rev C rev E dwg 07.04.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2213
Insert

Manufactured No 100 Each 211.0000 8



0210112110

Location	Loc Qty	Loc Code
ST008	211	
30107	35	
30809	176	

58

D3188-2P Purchased No



Spacepod Body

64596

110 Each 0.0000 1



1
04/3/10 CC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

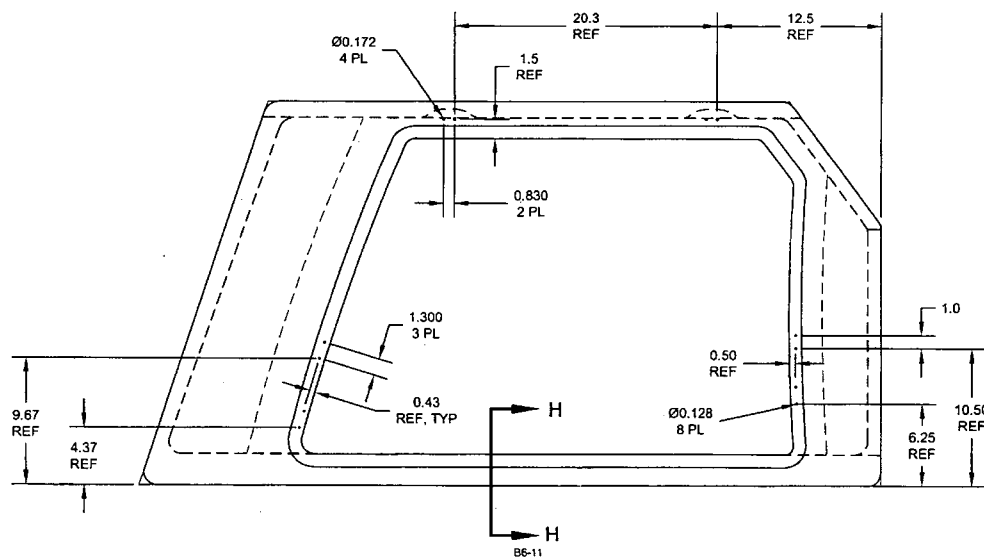
9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

021012109

W10:64596

RELEASED
2009-10-20

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 1 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

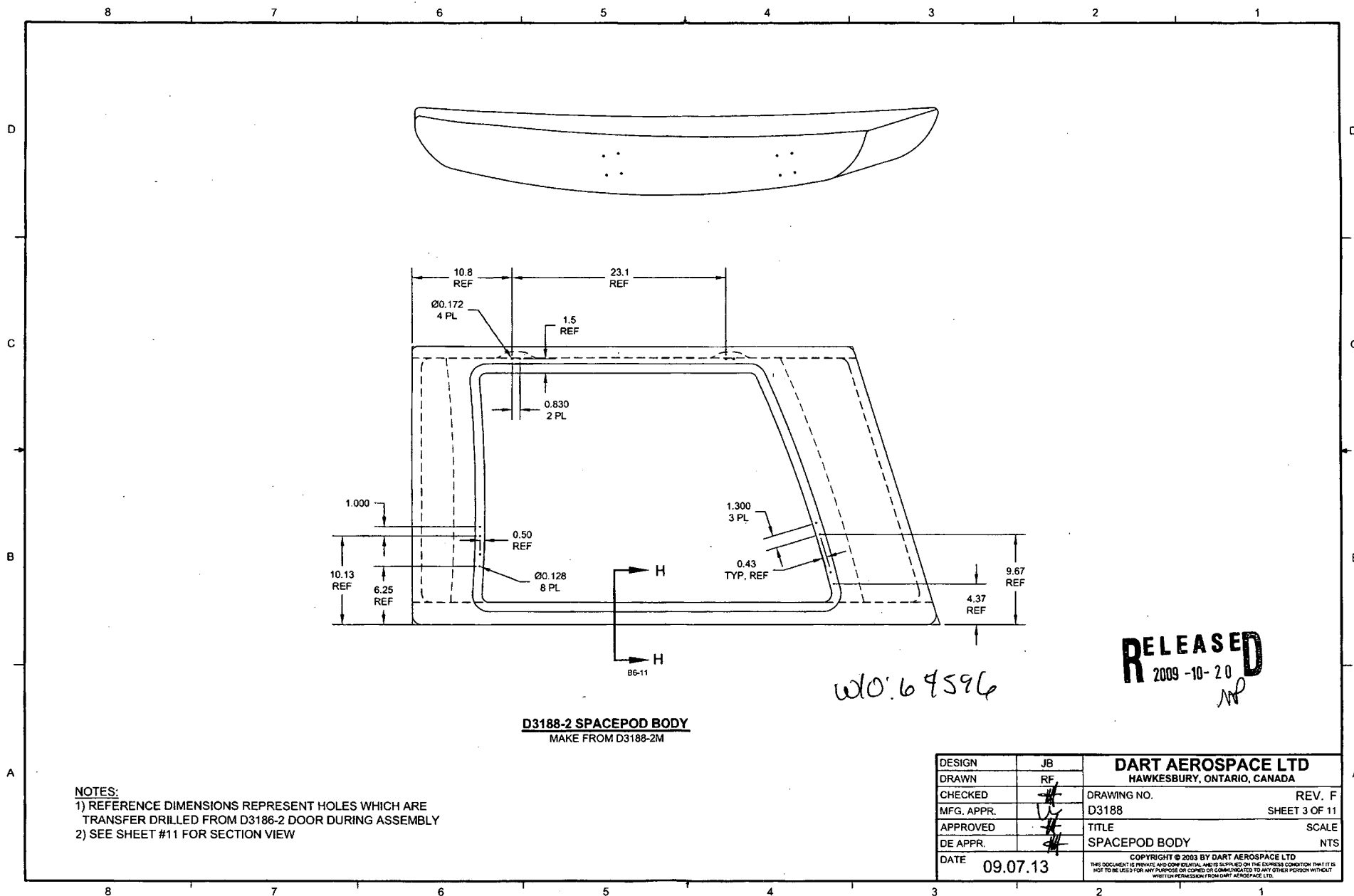
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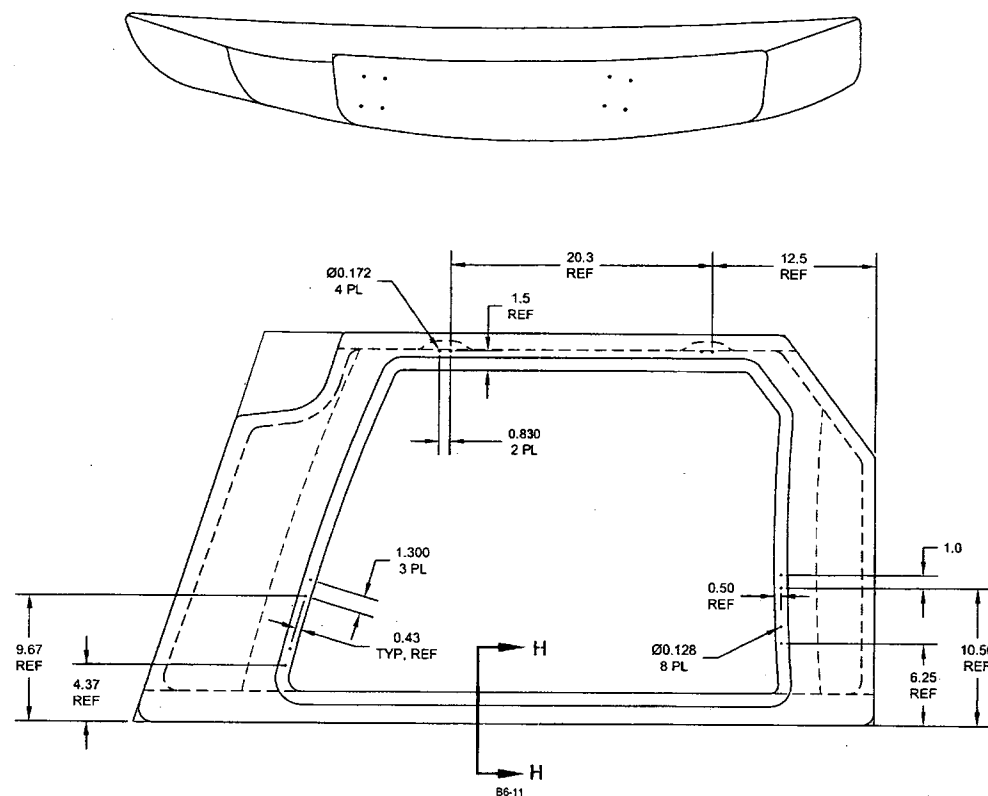
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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Q10.64596

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MFG. APPR.	#	D3188	SHEET 2 OF 11
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D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

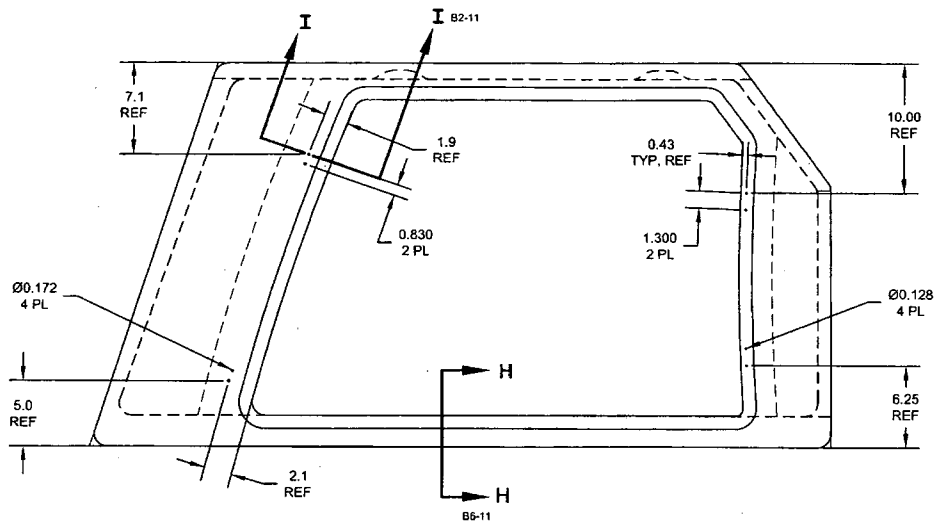
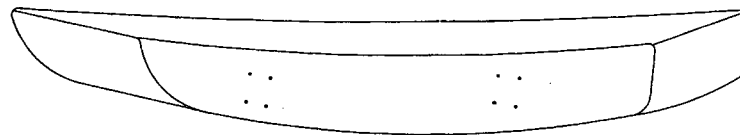
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

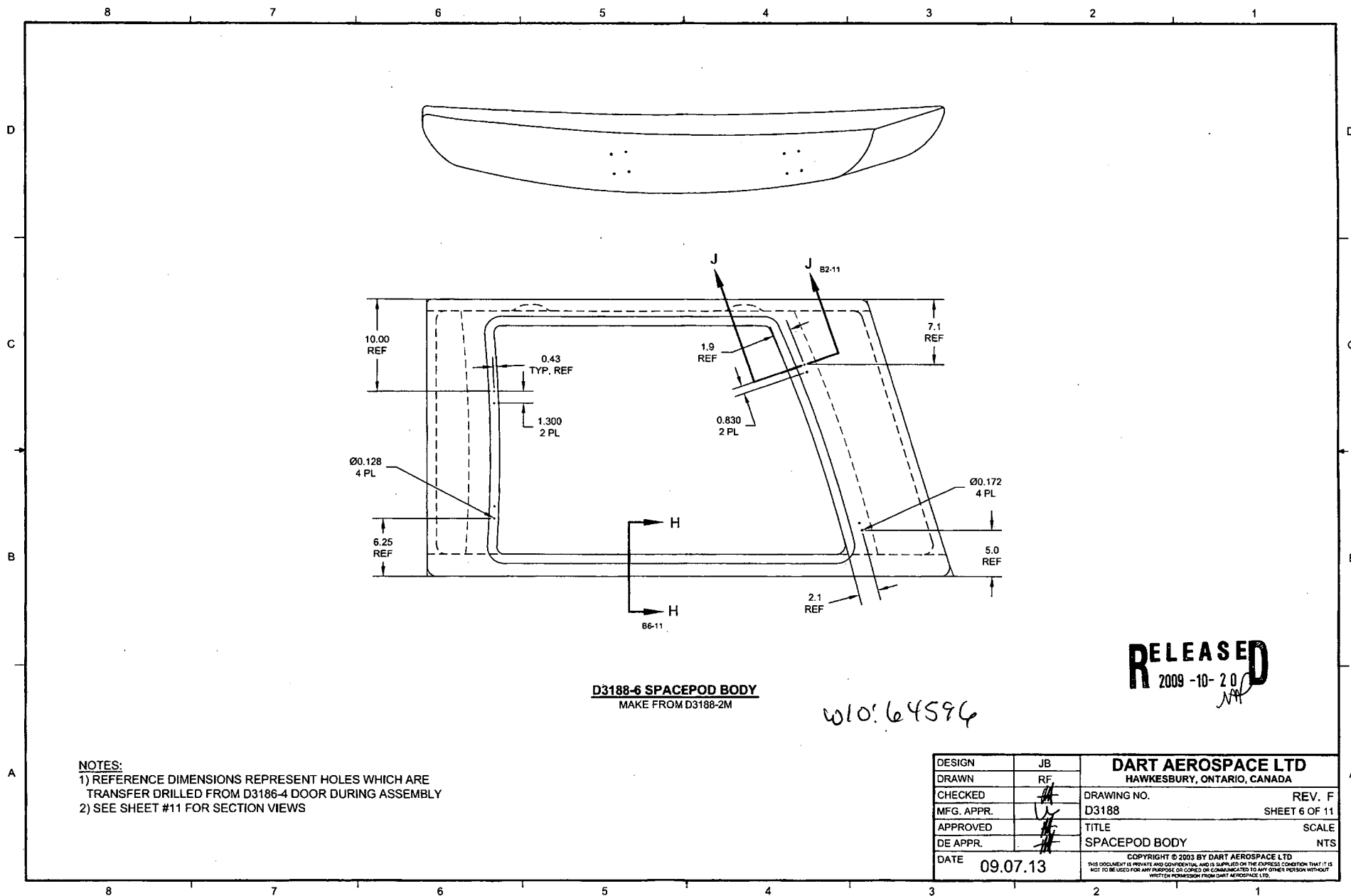
W10:64546

RELEASED
2009-10-20
MD

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

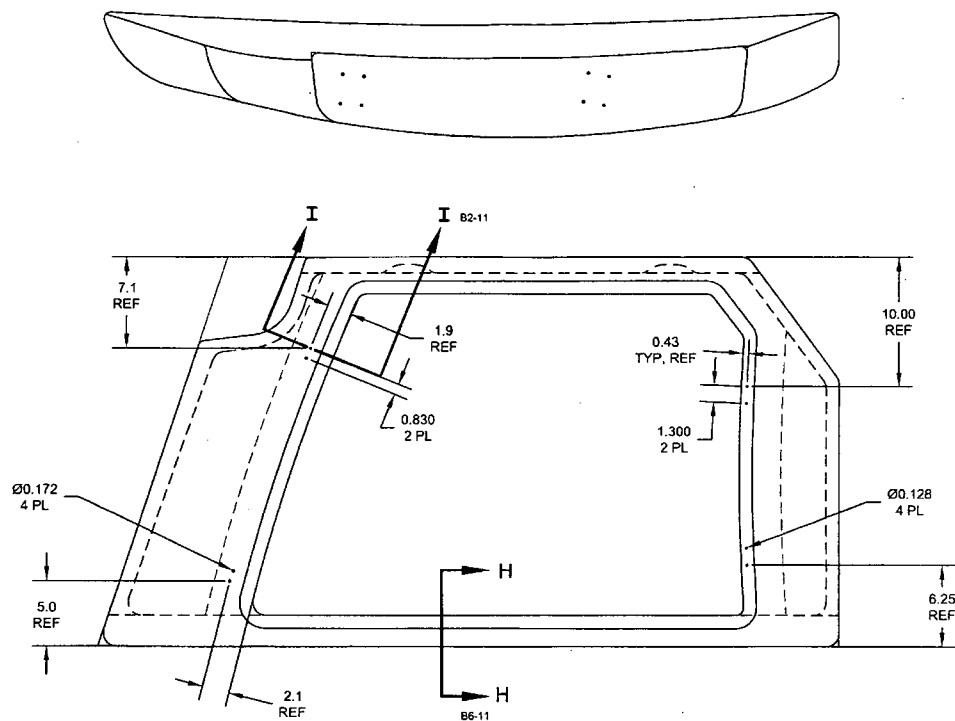
W10:64596

RELEASED
2009-10-20
M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE	09.07.13		



D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

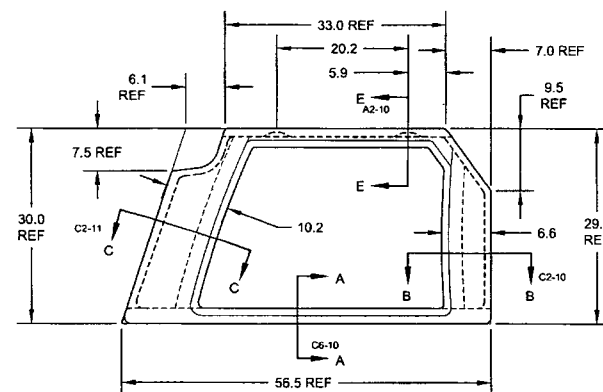
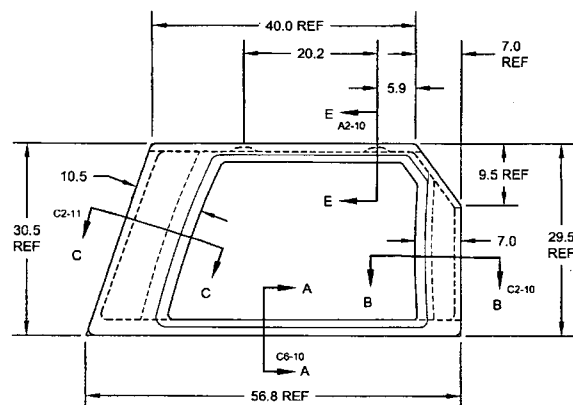
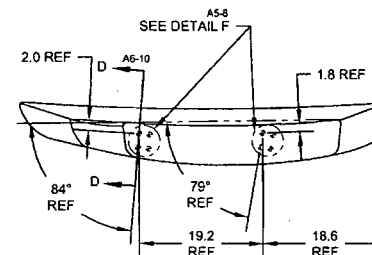
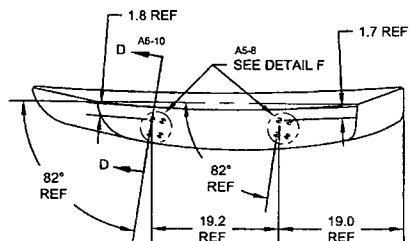
W10: 64596

RELEASED
2009-10-20
M

NOTE:

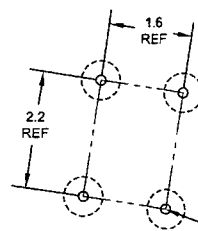
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD	
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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 7 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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D3188-1M SPACEPOD BODY

D3188-3M SPACEPOD BODY



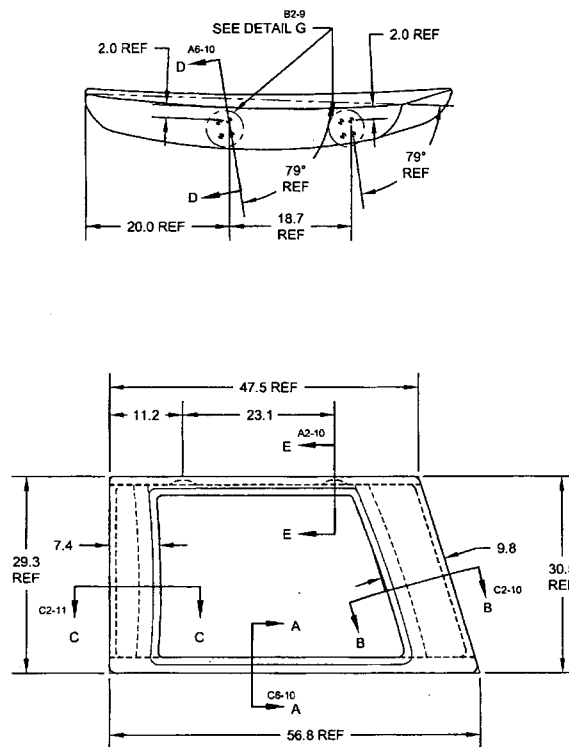
DETAIL F

INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A5-10

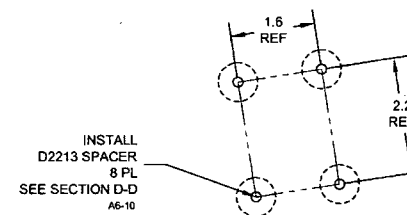
D3188-1M/-3M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2) SEE SHEET #10 FOR SECTION VIEWS.

RELEASED
2009-10-20

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3188	REV. F
MFG. APPR.		SHEET 8 OF 11	
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D3188-2M SPACEPOD BODY



DETAIL G D6-9

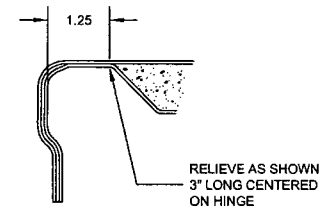
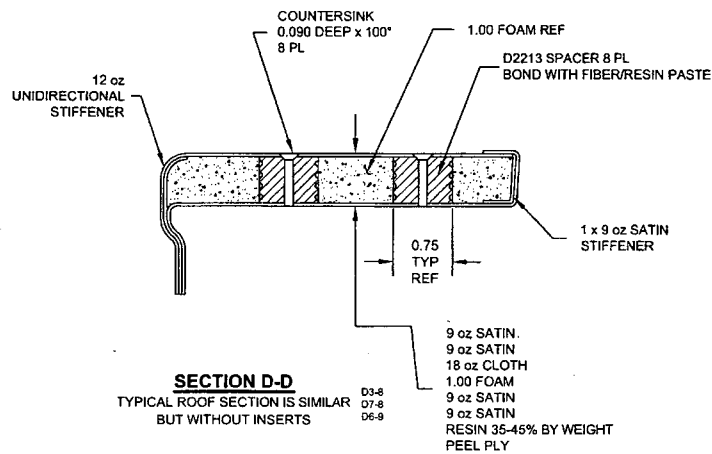
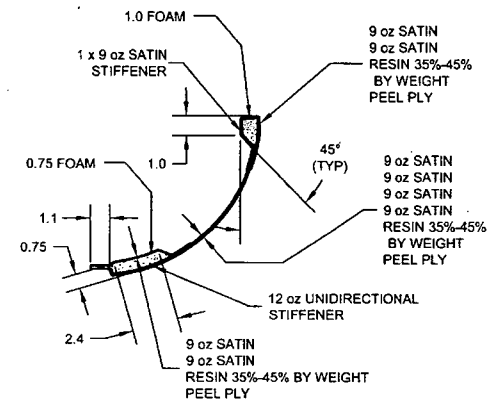
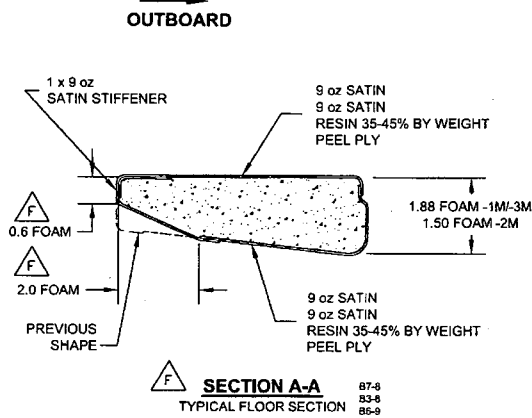
RELEASED
2009-10-20

W10:64396

D3188-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

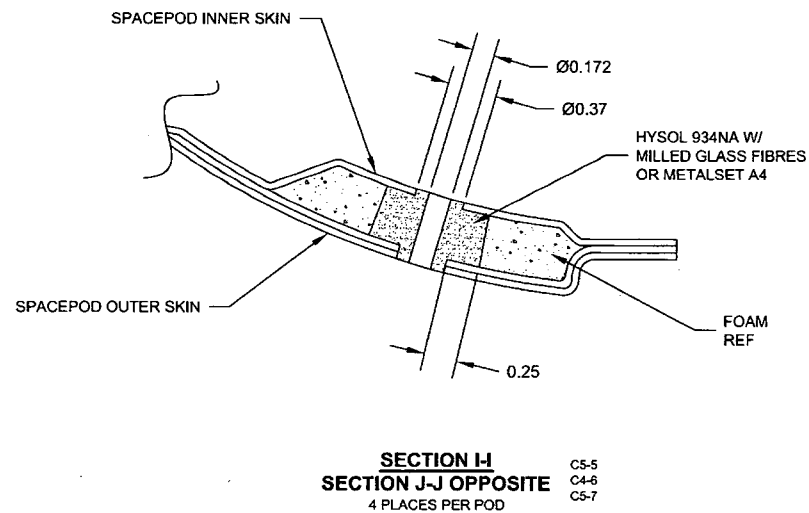
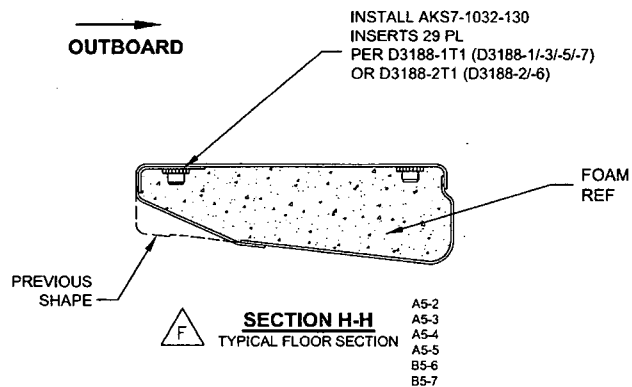
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 9 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O. 64596

RELEASED
2009-10-27

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 10 OF 11
APPROVED	RF	TITLE	SCALE
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RELEASED
2009-10-20
WMD

W10:64596

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	W	DRAWING NO.	REV. F
MFG. APPR.	W	D3188	SHEET 11 OF 11
APPROVED	W	TITLE	SCALE
DE APPR.	W	SPACEPOD BODY	NTS
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Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	37350
Customer #	DART US

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:
DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship to:
DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship via		F.O.B.		Terms		Salesperson	
PURO GROUND		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
01/03/2011	09/12/2010	16263	Chantal Lavoie		PO13107		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0060	Line 3 D31862P Spacepod Door RH B64597 Dwg. Rév.: E <u>No. série</u> B64597 <u>No. lot</u> 30723 U de M : Each			
1	0	1	DKC134-0071	Line 4 D31882P, Spacepod Body RH B64596 Dwg. D3188 Rév.: F <u>No. série</u> B64596 <u>No. lot</u> 30797 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-357

☒ Cust.

☐ Adm.

☐ Quality

☐ Ship.

Date: Lundi, 2010-12-13 17:09:32
Utilisateur: Pascal Carignan

Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: SPACEPOD BODY RH
Numéro Job	: 30797	Numéro Article	: DKC134-0071
Numéro Soumission	: 3763	Numéro Dessin	: D3188
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2010-12-13 No. B.V. :	Révision dessin	: F
Prsht Rev.	: NC	Matériel	: Fibre 7781 et résine 411-350
Prem. fois	: - - Type :	Date Dûe	: 2010-12-20 Qté: 1 UdM: UNITE
Job précédente	: 30796		
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de pièce Client: D3188-2		

Process Sheet Rév.: 02 ajout des nouveaux numéro d'IF/IG

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AC0085 FREKOTE 3,78L 44-NC

Commentair Qty.: 0.05 UNITE(s)/Unit Total : 0.05 UNITE(s)

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule selon IF134-0020.

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

3.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)

4.0 AC0884 Wrighton 5200 Bleu P3

Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)

5.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

6.0 AC0943 Stretchlon 200 poche à vide Vert

Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)

7.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-28776-2

8.0 AMB0349 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)

Fiberglass 12 oz Unidirectional N° de Lot: 1-22549-1

Date: Lundi, 2010-12-13 17:09:32
Utilisateur: Pascal Carignan

Feuille de Procédé

Cient: DART US DART AEROSPACE LTD
Numéro Job: 30797

Nom Dessin: SPACEPOD BODY RH
Numéro Article: DKC134-0071

Numéro Job:



Séq.: Machine ou Opération: Description :

9.0 AMB0213 WR1850 Roving 18oz. x 50"

Commentair Qty.: 0.350 KILOGRAMME(s)/Unit Total : 0.350 KILOGRAMME(s)
WR1850 Roving 18oz. x 50" N° de Lot: 1-22302-1

10.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 4.0000 ROULEAU(s)/Unit Total : 4.0000 ROULEAU(s)

11.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler les tissus selon IF134-0020.

Date: 7-01-11 Heure Début: — Heure Fin: — Sceau:

12.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0640 GALLON(s)/Unit Total : 0.0640 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

13.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.000 LITRE(s)/Unit Total : 2.000 LITRE(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-29297-1

14.0 AAC1540 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0040 GALLON(s)/Unit Total : 0.0040 GALLON(s)
Fibre de verre Miapoxy 66 N° de Lot: 1-7046-1

15.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Laminer la 1ère coquille selon IF134-0020.

Date: 26/01/11 Heure Début: — Heure Fin: — Sceau:

16.0 AMB0355 ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.750 FEUILLE(s)/Unit Total : 0.750 FEUILLE(s)
ATC core-cell A500 plain 4'x8' 1" thick N° de Lot: 1-6773-2

17.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.200 LITRE(s)/Unit Total : 0.200 LITRE(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-29297-1

18.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0064 GALLON(s)/Unit Total : 0.0064 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

Date: Lundi, 2010-12-13 17:09:32

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 30797

Numéro Article: DKC134-0071

Numéro Job:



Séq.:

Machine ou Opération:

Description :

19.0

AAC1611

Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)

Polybond B46F

N° de Lot:

1-27795-1

20.0

TAILLAGE

Faire le taillage du matériel



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs

Tailler et ajuster les Foam Core selon IF134-0020.

Date: 31-1-11

Heure Début: —

Heure Fin: —

Sceau:



21.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-29297-1

22.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0096 GALLON(s)/Unit Total : 0.0096 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

23.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Sceller les foam core selon IF134-0020.

Date: 31/01/11

Sceau:



Initiales:

S.V.C.G.

24.0

PERCAGE

Percage de trous



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Percer les foam core selon IF134-0020.

Date: 1/02/11

Sceau:



Initiales:

S.V.C.G.

25.0

AAC1611

Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s)

Polybond B46F

N° de Lot:

1-27795-1

26.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Installer les foam core selon IF134-0020.

Date: 7/02/11

Heure Début: 7:15

Heure Fin: 9:20

Sceau:



Date: Lundi, 2010-12-13 17:09:32

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 30797

Numéro Article: DKC134-0071

Numéro Job:



Séq.:

Machine ou Opération:

Description :

27.0

AAC1390

MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.100 KIT(s)/Unit Total : 0.100 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

N° de Lot:

1-26644-1

28.0

AAC1617

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.08 UNITE(s)/Unit Total : 0.08 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

N° de Lot:

29.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Usiner les foam core selon IF134-0020.

Date: 11-2-11

Heure Début:

Heure Fin:

Sceau:



30.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.600 KILOGRAMME(s)/Unit Total : 1.600 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-29826-1

31.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0536 GALLON(s)/Unit Total : 0.0536 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-29829-1

32.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Laminer les plis de 9oz selon IF134-0020.

Date: 17/02/11

Heure Début:

Heure Fin:

Sceau:



33.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire le taillage selon IF134-0022.

Date: 21-2-11

Heure Début:

Heure Fin:

Sceau:



34.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0144 GALLON(s)/Unit Total : 0.0144 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-29829-1

Date: Lundi, 2010-12-13 17:09:32
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30797

Nom Dessin: SPACEPOD BODY RH
Numéro Article: DKC134-0071

Numéro Job:



Séq.: Machine ou Opération: Description :

35.0 AAC1540 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)
Fibre de verre Miapoxy 66 N° de Lot: 1-7076-1

36.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.450 KILOGRAMME(s)/Unit Total : 0.450 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-29826-1

37.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs

Faire le laminage des derniers plis 9oz selon IF134-0020.

Date: 23-2-11 Heure Début: ——— Heure Fin: ——— Sceau:

38.0 AAC1610 Spacer N° D2213

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Spacer N° D2213 N° de Lot: 1-5816-1 1-29400-1

39.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Faire l'assemblage des inserts selon IG0097.

Date: 23-2-11 Heure Début: ——— Heure Fin: ——— Sceau:

40.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-28961-2

41.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-28961-3

42.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer la pièce selon IG0008.

Quantité: 1 Date: 24-2-11 Sceau:

Date: Lundi, 2010-12-13 17:09:32
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30797

Nom Dessin: SPACEPOD BODY RH
Numéro Article: DKC134-0071

Numéro Job:




Séq.: Machine ou Opération: Description :

43.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008 et la fiche technique.

Qté: 1 Date: 1 Mars 11 Sceau:  # de fiche de mélange: N/A

44.0 AAC1390 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.020 KIT(s)/Unit Total : 0.020 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

N° de Lot: 1-28476-1

45.0 AAC1617 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.08 UNITE(s)/Unit Total : 0.08 UNITE(s)

Durcisseur Polysoft #004009 Sikkens


N° de Lot: 1-29253-1

46.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Faire les réparations de finition s'il y a lieu selon IG0008.


Date: 28-2-11 Heure Début: — Heure Fin: — Sceau:  N.T.

47.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection générale de la pièce selon le dessin par le département de la qualité.

Date: 1 Mars 11 Sceau:  Initiales: JS

48.0 EMBALLAGE Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage dans le contenant approprié.

Quantité: 1 Date: 1 Mars 11 Sceau: L.B